



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3407-5

Job Sheet 172191



Part No: D3407-5

Job Qty: 21 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/13/18

Job Tracking No:

Due Date: 2/28/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	21 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Waterjet		SC 18/02/17
100	Waterjet	21 pcs	2/27/18	2/27/18	0.03	1.92	Waterjet1		SC 18/02/17
110	QC	21 pcs	2/27/18	2/27/18	0.00	0.00	QC2		SC 18/02/17
115	Lathe Conv	21 pcs	2/28/18	2/28/18	0.00	1.39	Lathe Conv-1		KA 18-03-05
117	QC	21 pcs	2/28/18	2/28/18	0.00	0.00	QC2		KA 18-03-05
120	QC	21 pcs	2/28/18	2/28/18	0.00	0.00	QC8		J.C. 18-03-05
130	Packaging	21 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3		
140	QC21-SA	21 Ea	2/28/18	2/28/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: G Prog Rev: G 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M174PH-H900B0.250X4.000	17-4 H900 SS Bar 0.250" X 4.000"	5.5860 ft (.266 ea)	90-Start up Operation	S029859

M17-4-B0.250X4.00

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M174PH-H900B0.250X4.000	6	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240	0,253	
2	Tow Ring	3.000inches ± 0.030	3.030 2.970	3,002	
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049	2,050	
4	Tow Ring	0.750inches ± 0.030	0.780 0.720	0,751	

M17-4-B0250X4.000
S029859

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Container No: S044518



Part: D3407-5

Job No: 172191

Serial No/Batch: S044518

Revision: D3407

Inspector:

Date: 02/22/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches ± 0.010	0.073 0.053		
2	Tow Ring	0.26520Inches + 0.00160 - 0.00170	0.26680 0.26350	1/4-28 UNF	
3	Tow Ring	0.24575Inches ± 0.00325	0.24900 0.24250	Major ♦	
4	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
5	Tow Ring	0.363Inches ± 0.010	0.373 0.353		
6	Tow Ring	0.750Inches ± 0.010	0.760 0.740		
7	Tow Ring	0.100Inches ± 0.010	0.110 0.090	Radius	
8	Tow Ring	0.470Inches ± 0.010	0.480 0.460		
9	Tow Ring	0.500Inches ± 0.010	0.510 0.490		
10	Tow Ring	3.25Inches ± 0.01	3.26 3.24		
11	Tow Ring	4.250Inches + 0.000 - 0.010	4.250 4.240		
12	Tow Ring	5.270Inches ± 0.010	5.280 5.260		
13	Tow Ring	0.150Inches ± 0.010	0.160 0.140		
14	Tow Ring	0.550Inches ± 0.010	0.560 0.540		
15	Tow Ring	0.625Inches ± 0.010	0.635 0.615		
16	Tow Ring	0.250Inches + 0.010 - 0.000	0.260 0.250		

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